

Work Order ID 95240

95240

Page 1

January 3, 2013 2:54:15 PM

Item ID: D3885-1

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Standard Web

Start Date: 1/03/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/04/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: CL Date: 13/01/03 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Draw Nbr	Revision Nbr	Operation Description	Set Up/Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------	--------------	-----------------------	------------------	---------	--------	-----------	------------	------------	---------------	-------------

100		Draw Nbr	Revision Nbr
		D3885	B

100 0.00

100

Purchasing

Memo

Purchasing

Purchasing

Issue P/O: 18242

Supplier: George A. Wright & Son Ltd.

Machine as per Dwg D3885

Conformity sheet required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

Packaging

0.00

CL 12/10/24 10

Pto ->

13/01/14 (10)
8

NCR: ☒ Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *dot*

Date: 13/05/05

QA Closed: *dot*

Date: 13/4/23

Work Order: <u>95240</u>				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. <u>D3885-1</u>				Rework <input type="checkbox"/>		Skid-tube <input type="checkbox"/>		Crosstube <input type="checkbox"/>		Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>	
NCR No. <u>17-2530</u>				Scrap <input checked="" type="checkbox"/>		Machining <input type="checkbox"/>		Small Fab <input type="checkbox"/>		Prod. Eng. Coord. <input type="checkbox"/>		Quality <input type="checkbox"/>	
				Use-as-is <input type="checkbox"/>		Thermoforming <input type="checkbox"/>		Finishing <input type="checkbox"/>		Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>	
				Work Order Update <input type="checkbox"/>		Large Fab <input type="checkbox"/>		Composite <input type="checkbox"/>		Supplier <input checked="" type="checkbox"/>			

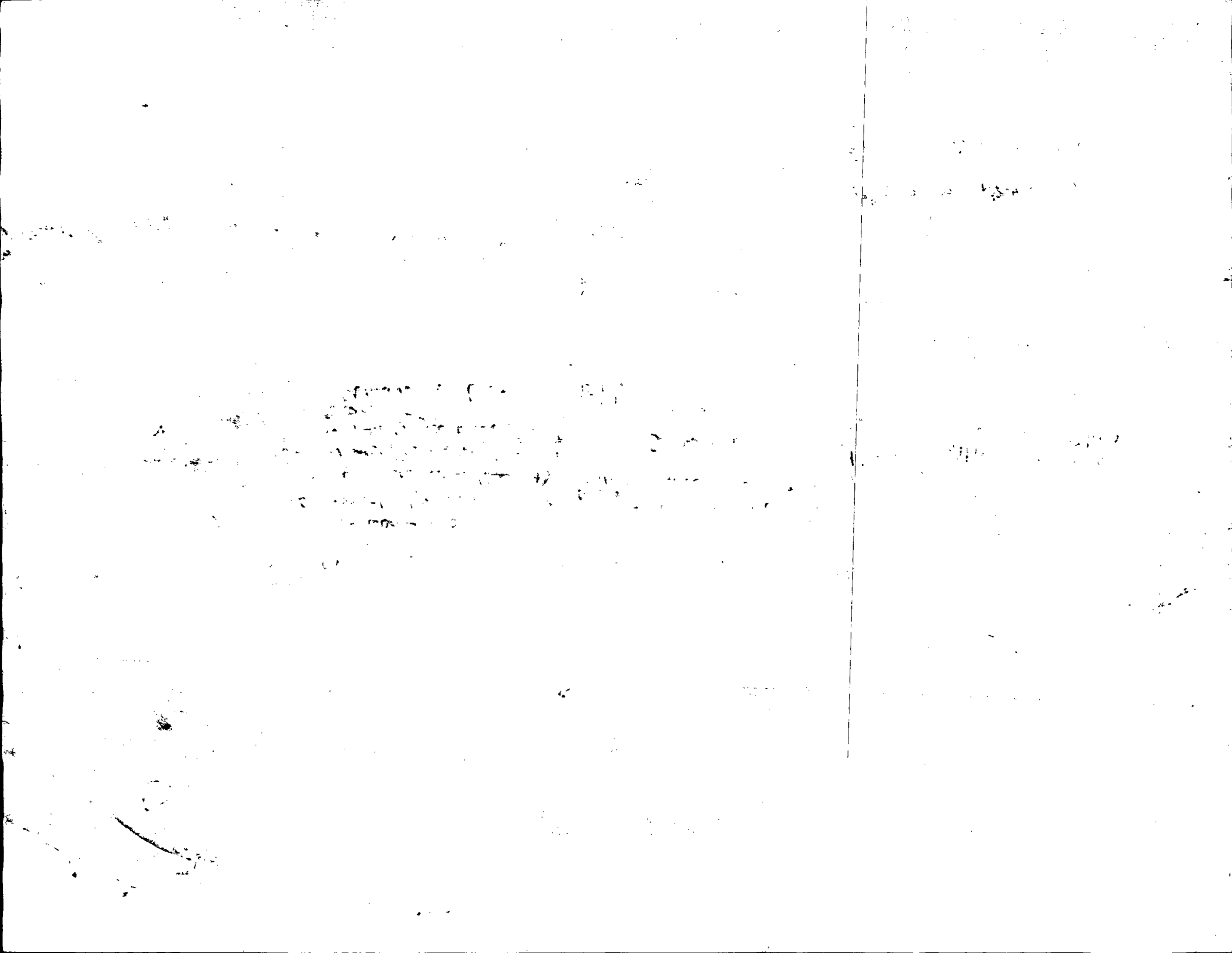
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	<i>Blue/15</i>	<i>100</i>	<i>x2 total</i>	Qty x2 webs SCRAP	<i>(DAS 15 9-83)</i> <i>AS2042 13/1/15</i>	<i>Signature: [illegible]</i> <i>SCRAP + Destroy Qty x1</i> <i>(have returned to SCRAP @ DAS)</i>	<i>(DAS 15 9-83)</i> <i>13-1-15</i>	<i>(DAS 16 9-83)</i> <i>13/1/15</i>	<i>(DAS 16 9-83)</i> <i>AS2042 13/1/15</i>
Equip/Tooling				1- web was extruded too warped/cracks unable to use.					
Operator				R.L. supplier issue (low mat)					
Material				2-webs at SCRAPed Qty x1					
Setup				web by a nitch cut in Fwd					
Other				END.					
Process				R.L. supplier issue (we say)					
Supplier									
Training									
Unapproved									

FAULT CATEGORY			
Landing Gear		General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Other
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions	

See [illegible] 13-2531 Weyay

1st web by extrusion supplier

2nd by Weyay. (Machining)



Work Order ID 95240

95240

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Page 2

Item ID: D3885-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Standard Web
 Start Date: 1/03/13 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 1/04/13 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID	Operation Description	Set Up / Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reform Number	Imp. Setup
Work Center ID									
120	QC6- Inspect dimensions to drawing	0.00				8			
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC5- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

1344

DC 13/04/17

⑧ SAD 13-04-17

Work Order ID 95240

January 3, 2013 2:54:15 PM

95240

Page 3

Item ID: D3885-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Standard Web

Start Date: 1/03/13 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 1/04/13 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>LE</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

⑧ SAD 13-04-17

13/4/22 J

13-04-17

Picklist Print

January 3, 2013 2:54:14 PM

Page 1

Work Order ID: 95240

Parent Item: D3885-1

Parent Item Name: Standard Web

Start Date: 1/03/13

Required Date: 1/04/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3882-1-130

Extrusion "I" Beam

Manufactured

No

110

Each

21.0000

1

OK 12/10/24

Location

Loc Qty

Loc Code

HALL

16

51826

16

LG

5

51826

5

8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

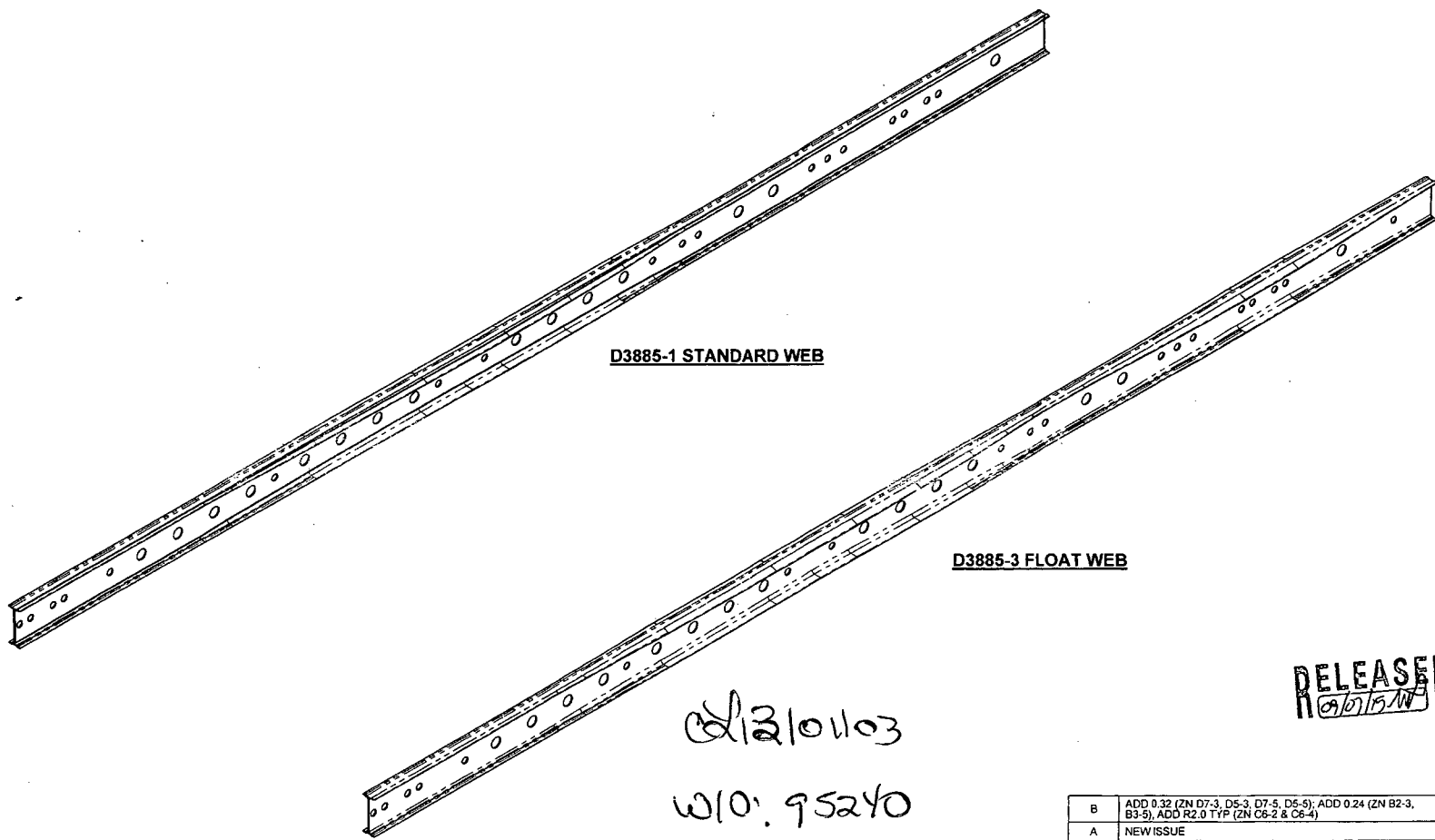
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

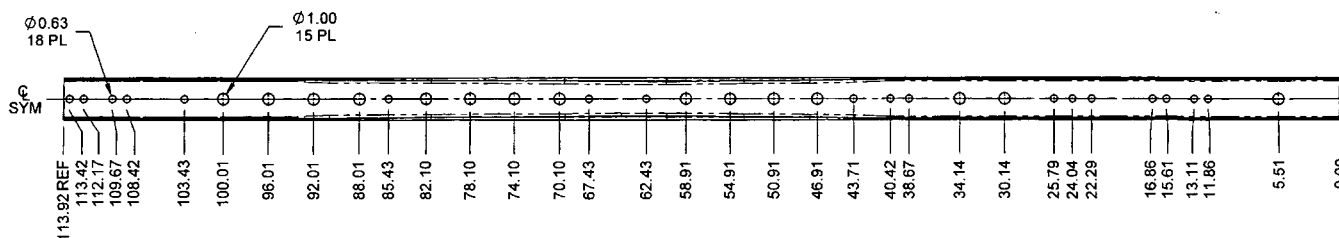
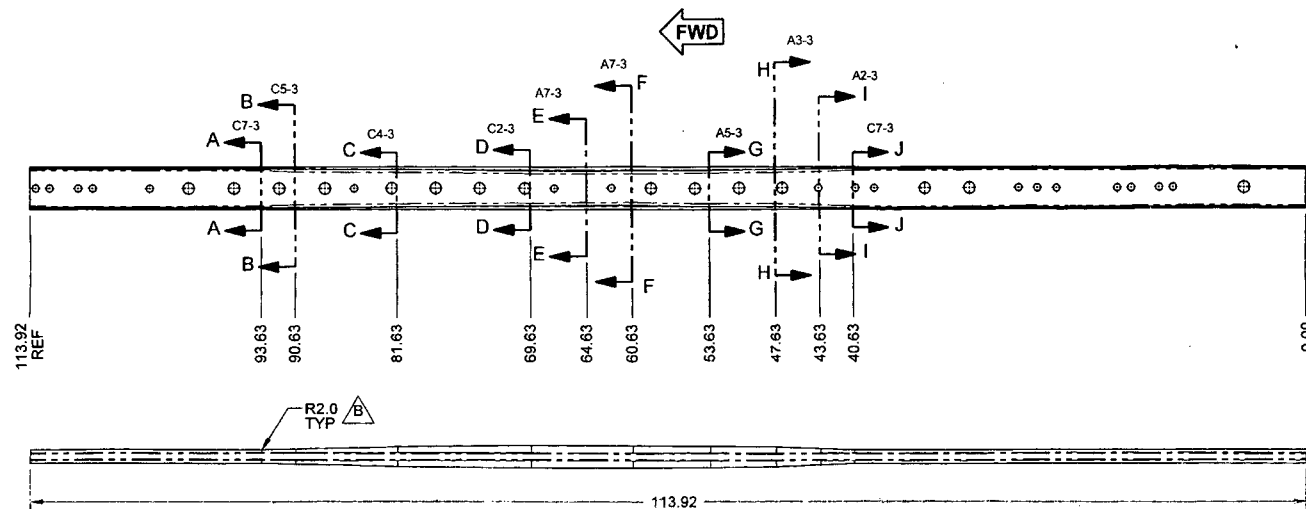
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		



012101103
W10.95240

RELEASED
09/06/30

B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-3), ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	RF	D3885	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		WEB	NTS
DE APPR.		<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DATE	09.06.30		



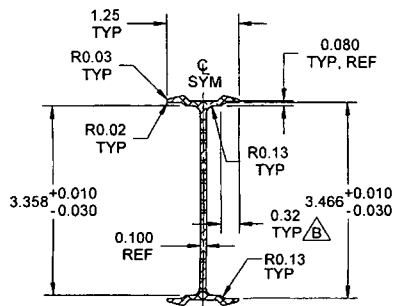
D3885-1 STANDARD WEB

D3885-1 NOTES:

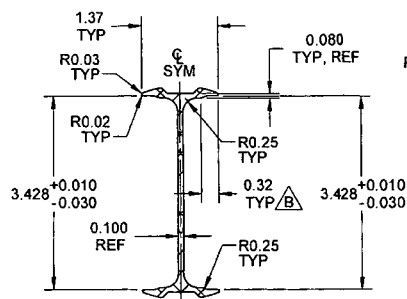
- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 8.51 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3885	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
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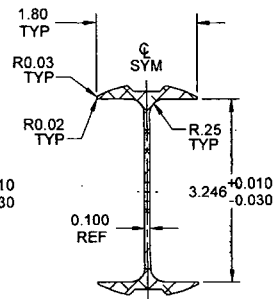
RELEASED
09/27/15



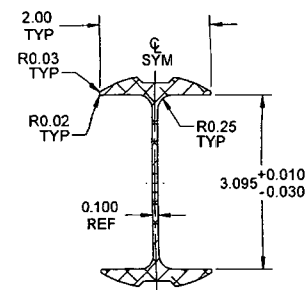
**SECTION A-A
& SECTION J-J**
SCALE 5X
D6-2
D4-2



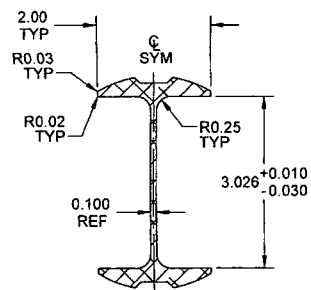
SECTION B-B
SCALE 5X
D6-2



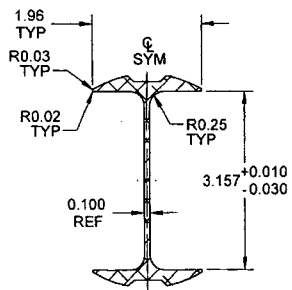
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SCALE 5X
D6-2



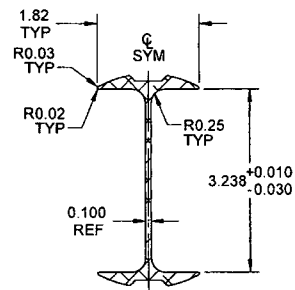
SECTION D-D
SCALE 5X
D5-2



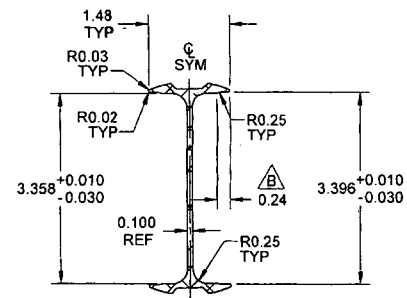
**SECTION E-E
& SECTION F-F**
SCALE 5X
D5-2



SECTION G-G
SCALE 5X
D4-2



SECTION H-H
SCALE 5X
D4-2

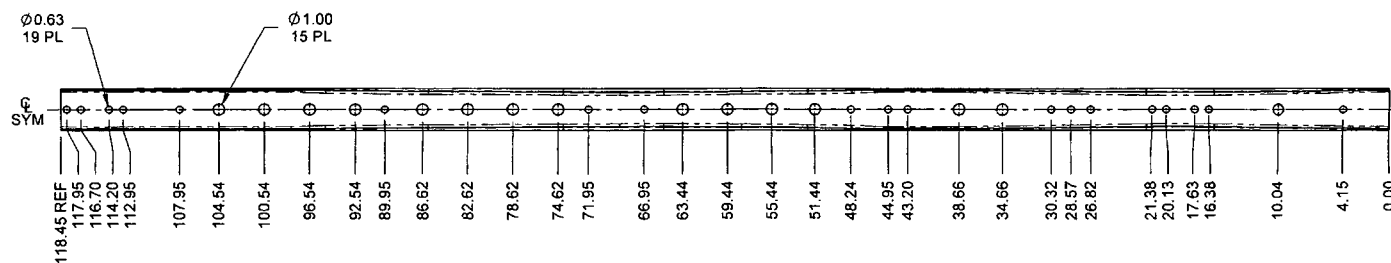
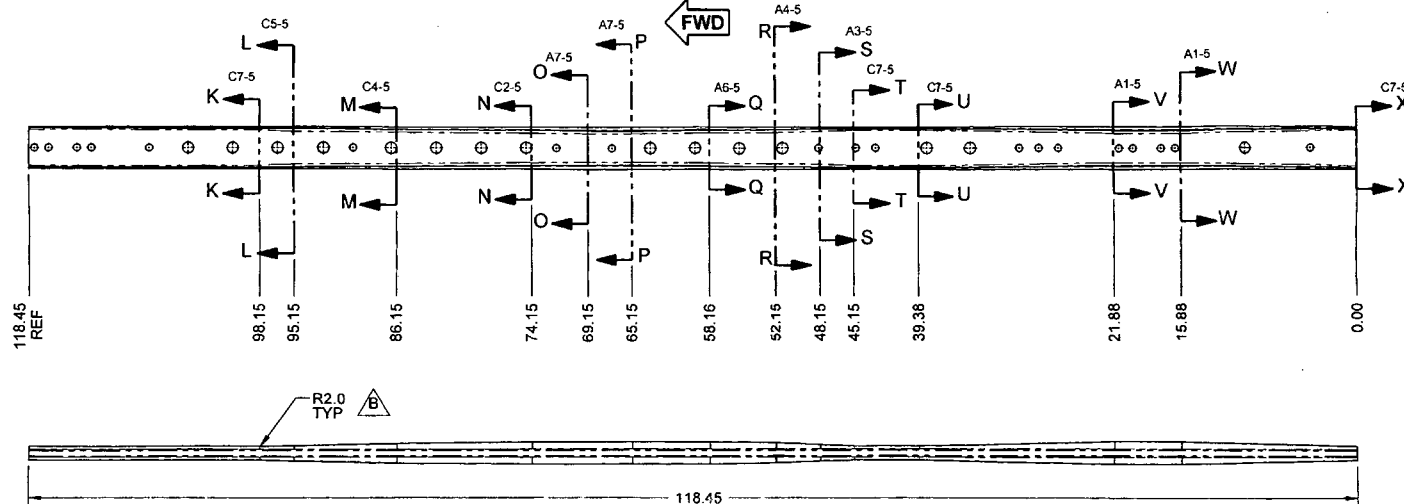


SECTION I-I
SCALE 5X
D4-2

RELEASED
09/15/03

D3885-1 STANDARD WEB SECTION VIEWS

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 3 OF 5
APPROVED		TITLE	SCALE
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D3885-3 FLOAT WEB

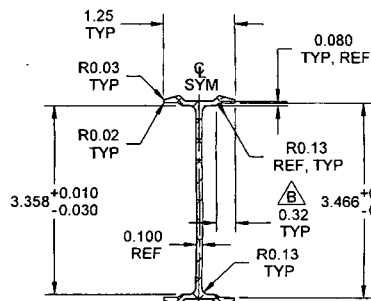
D3885-3 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 10.14 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3885	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
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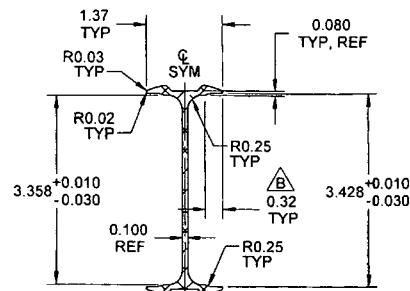
RELEASED
09/07/15 AN

8 7 6 5 4 3 2 1

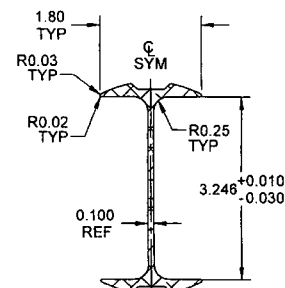


**SECTION K-K
& SECTION Y-Y
& SECTION U-U
& SECTION X-X**
SCALE 5X

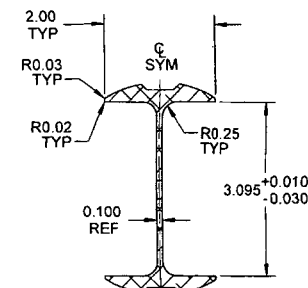
D7-4
D4-4
D3-4
D1-4



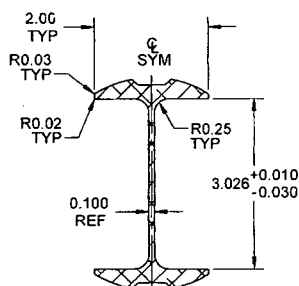
SECTION L-L D6-4
SCALE 5X



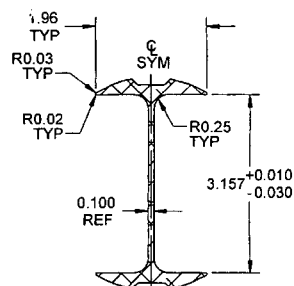
SECTION M-M D6-4
SCALE 5X



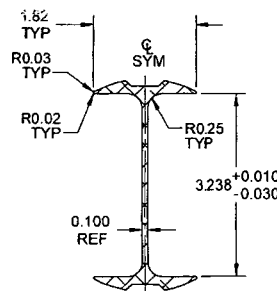
SECTION N-N D5-4
SCALE 5X



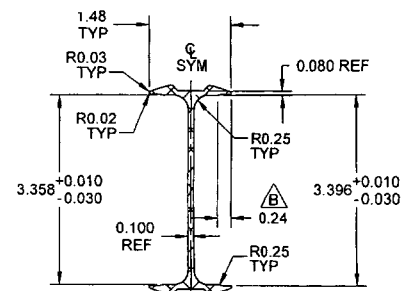
**SECTION O-O
& SECTION P-P** D5-4
SCALE 5X



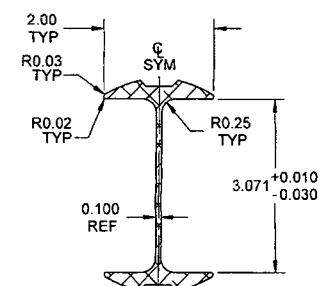
SECTION Q-Q D4-4
SCALE 5X



SECTION R-R D4-4
SCALE 5X



SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
D2-4
SCALE 5X

RELEASED
2/17/15

D3885-3 FLOAT WEB SECTION VIEWS

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3885	REV. B
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE WEB	SCALE NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	09.06.30		

8 7 6 5 4 3 2 1

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

91646
JP